

Date: Thursday, 2/9/2006 1:43:35 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 25759B		
Estimate Number	: 10207		
P.O. Number	: N/A	Part Number	: D2989043
This Issue	: 2/9/2006	Drawing Number	: D2989 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 25757B	Material	: N/A
Written By	: See comment below	Due Date	: 2/7/2006
Checked & Approved By	: RF 06.02.10	Qty:	1
Comment	: Est Rev:I Removed D2989-041 05-11-03 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31821	Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part number Description Batch	
	2 D3182-1	Hinge B25845	
			PD 06-03-13
2.0	D34423	Shim	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part number Description Batch	
	2 D3442-3	Shim B23545	
			PD 06-03-03
3.0	M304EX07516F	Expanded Metal Flat Stai	
		Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)	
		Pick:	
		Qty Part number Description Batch	
	15sf M304EX0.75-16F	Expanded Metal M100071	
			PD 06-03-03
4.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)	
		3/4" x 3/4" x 0.063" wall 304/316 SStubing.	
		Batch: M100138	
			R 06-03-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 25759B

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note:D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

PD

06-03-13

①

6.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

06/03/13

①

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

M 06 03 14

①

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

06/03/16

9.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/03/17

Job Completion



U 06.03.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY		SCALE NTS
A	00.10.27 NEW ISSUE		
B	05.06.07 ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS		

RELEASED

05-08-19

PARTS LIST:

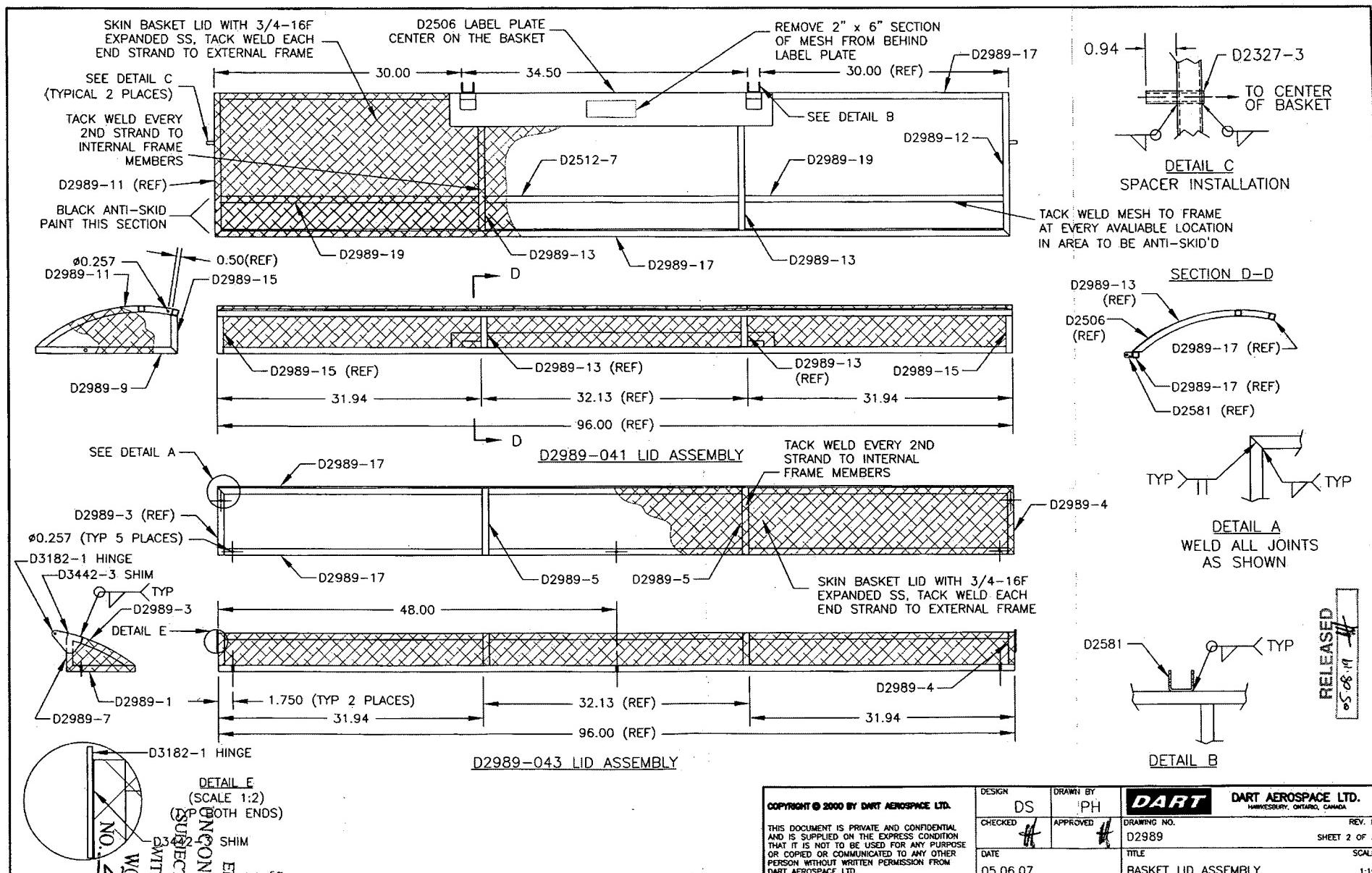
Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
1		D2989-1	STRUT
1		D2989-2	STRUT
1		D2989-3	STRUT
1		D2989-4	STRUT
2		D2989-5	STRUT
2		D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
2		D3182-1	HINGE
2		D3442-3	SHIM

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236 SHOP COPY
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F) RETURN TO ENGINEERING
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3. UNCONTROLLED COPY
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. **SPRAY PAINT** WITHOUT NOTICE
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WORK ORDER NO. 25759B

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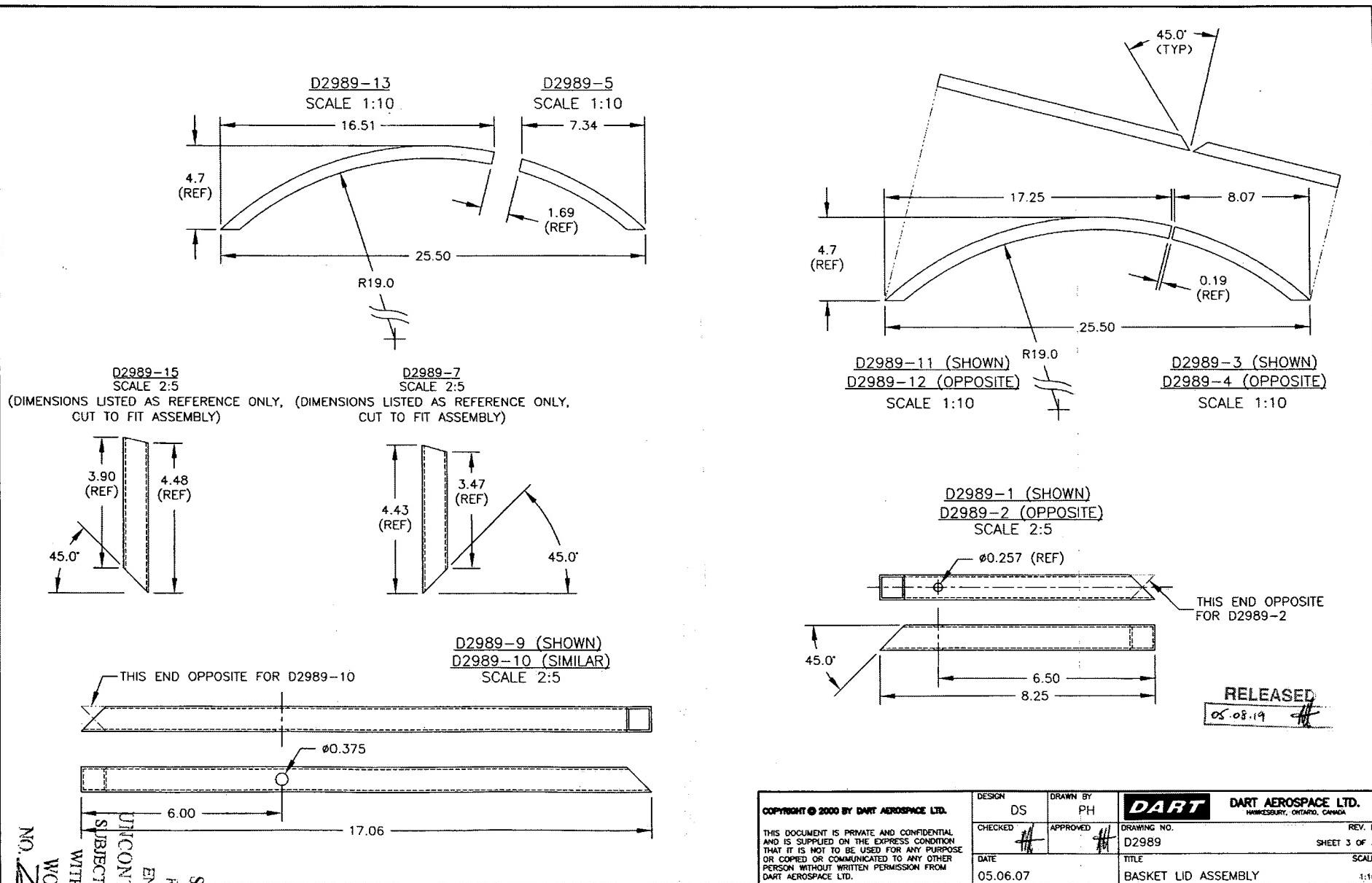
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DESIGN DS	DRAWN BY PH	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	D2989	REV. B SHEET 2 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY	SCALE 1:10	

WORK ORDER NO. 257593
SUBJECT TO AMENDMENT
RETURN TO ENGINEERING
NOTICE
CONTROLED COPY
NO. 2



SHOP COPY
RETURN TO
ENGINEERING
UNICON ROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **257595**